Technical data sheet EN180123BG	Cored welding wire **HARDFACE Nb-G**	Welding Alloys

CLASSIFICATION

EN 14700: T Fe6

DESCRIPTION

- Metal-cored wire for gas shielded metal arc hardfacing
- Produces a hard overlay resisting abrasion and impact
- Finely dispersed hard carbide phases optimise anti-wear properties
- User friendly for welding multiple pass welds as there is no hinder from slag

APPLICATIONS

- HARDFACE Nb-G is designed for hardfacing of items subjected to impact, gouging and abrasion under high stresses. It gives a highly abrasion-resistant crack-free weld metal which may be machined despite its high hardness and is suitable for multi-layer deposits.

Examples

Crushing hammers and rollers, leading edges and teeth of excavator buckets, bulldozer and scraper blades, rotary crusher cones, dipper teeth, etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb	Fe
1.5	0.8	0.8	6.5	6.0	Bal.

Structure: martensite with finely dispersed niobium carbide particles.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness - 3 layers on mild steel: 56 HRc

SHIELDING GAS

EN ISO 14175 M12 (Ar + 2 - 5% CO_2)

OPERATING CONDITIONS

Diameter [mm]	Current type*	Current [A]	Voltage [V]	Stick-out	Gas flow
1.2	DC (+), DC (-)	100 - 300	25 - 30	15 - 20 mm	10 - 20 l/min.
1.6	DC (+), DC (-)	200 - 350	25 - 30	15 - 20 mm	10 - 20 l/min.

Recovery: 98%

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	1.2 - 1.6 mm
Spool type	EN ISO 544 – ASME IIC SFA-5.2M: Basket spool BS300
Weight	15 kg

Other packaging: please consult us